

Date: Thursday, 29/05/2008 11:09:36 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOOR DOUBLER		
Job Number	: 39576		Part Number	: D3594044		
Estimate Number	: 12942		Drawing Number	: D3594 REV A		
P.O. Number	:		Project Number	: N/A		
This Issue	29/05/2008	S.O. No. :	Drawing Revision	: A		
Prsht Rev.	: NC		Material	:		
First Issue	/: /	Type : SMALL /MED FAB	Due Date	06/06/2008	Qty:	10 Um: Each
Previous Run	: 38165					
Written By	:					
Checked & Approved By	: <u>JUL 08.5.29</u>					
Comment	: Est Rev :A New Issue 07-01-22 EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet
Comment: Qty.: 0.5355 sf(s)/Unit Total : 5.3550 sf(s) 6061-T6 .080 Sheet Batch: <u>101904</u> <u>HB 8-6-3</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3594 Dwg Rev: <u>A</u> <u>HB 8-6-3</u> Prog Rev: <u>A</u> (10)		
2-Deburr if necessary <u>HB 8-6-3</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>HB 8-6-3</u>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>5080603 x 10</u>		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 C'SINK AS PER DWG D3594 <u>2108/06/03</u> (10)		

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Job Number: 39576		Part Number: D3594044
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP <i>Job 06-04</i>
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 <i>BL 08-06-04</i>
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION <i>Fd 08/06/04</i>
9.0	MS210695	Anchor nuts <i>1107938</i>
10.0	MS20426AD44	Rivet <i>11021</i>
11.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 <i>CD 08/06/10</i>
12.0	QC5	INSPECT WORK TO CURRENT STEP <i>CD 08/06/10</i>
13.0	PACKAGING 1	PACKAGING RESOURCE #1 <i>CD 08/06/10</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 29/05/2008 11:09:37 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 39576

Part Number: D3594044

Job Number:



Seq. #:	Machine Or Operation:	Description :
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14.0 QC21 FINAL INSPECTION/W/O RELEASE



08/06/12 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-06-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39516
Description: Floor Doubler, RH	Part Number:	D3594-4
Inspection Dwg: D3594	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

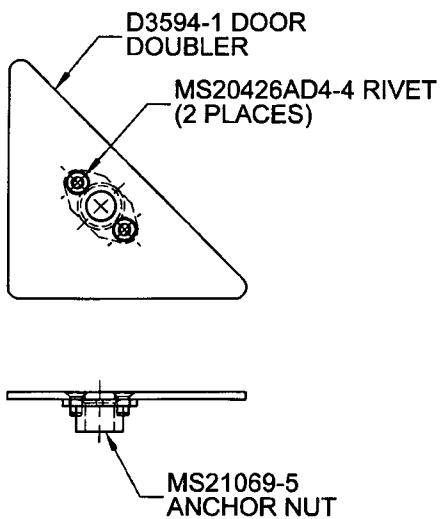
Measured by:	<u>B</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	9-6-3	Date:	9/6/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	P/O D3594-044	KJ/JLM <i>[Signature]</i> <i>[Signature]</i>

DART

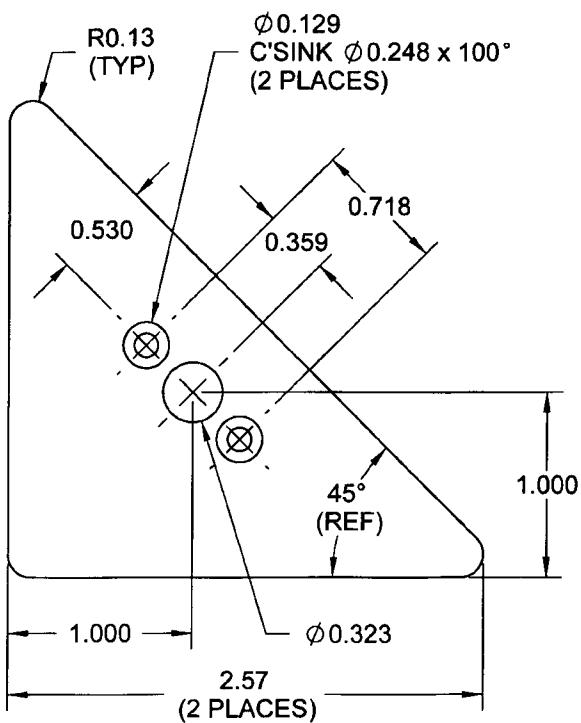
DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D3594
DATE 07.04.13		SCALE 1:1
REV A	DATE 07.04.13	DESCRIPTION NEW ISSUE

RELEASED
07.07.11 B
Per Rev A



D3594-041 DOOR DOUBLER ASSEMBLY 
SCALE 1 : 2

QTY -041	P/N	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069-5	ANCHOR NUT
2	MS20426AD4-4	RIVET



D3594-1 DOOR DOUBLER  

NOTES:

1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.080)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

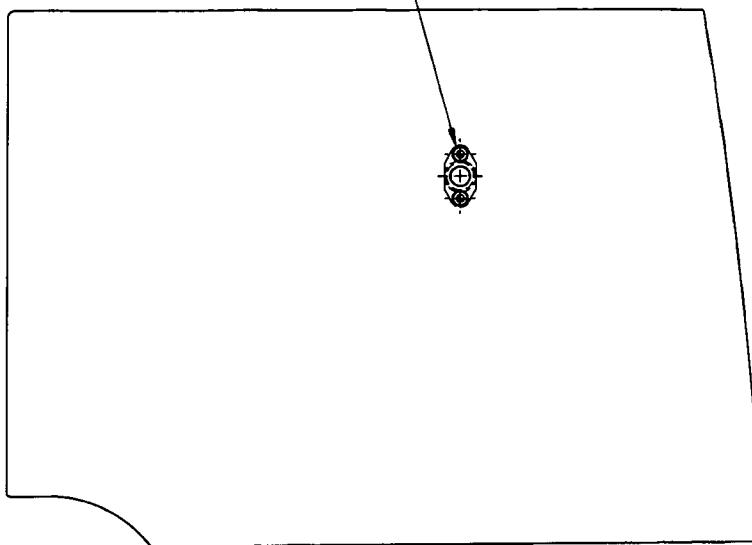
SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 39576

DART

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3594	REV. A SHEET 2 OF 3
DATE 07.04.13		TITLE FLOOR DOUBLER ASSEMBLY	SCALE 1:3

RELEASED

07.07.11

Per 80041021 MS20426AD4-4 RIVET
(2 PLACES)MS21069-5
ANCHOR NUTD3594-3 FLOOR DOUBLER (D3594-043)
D3594-4 FLOOR DOUBLER (D3594-044)**D3594-043 FLOOR DOUBLER ASSEMBLY**
(D3594-044 OPPOSITE)

QTY -043	QTY -044	P/N	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASS'Y, LH
	X	D3594-044	FLOOR DOUBLER ASS'Y, RH
1		D3594-3	FLOOR DOUBLER, LH
	1	D3594-4	FLOOR DOUBLER, RH
1	1	MS21069-5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET

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WORK ORDER
NO. 39574

NOTES:

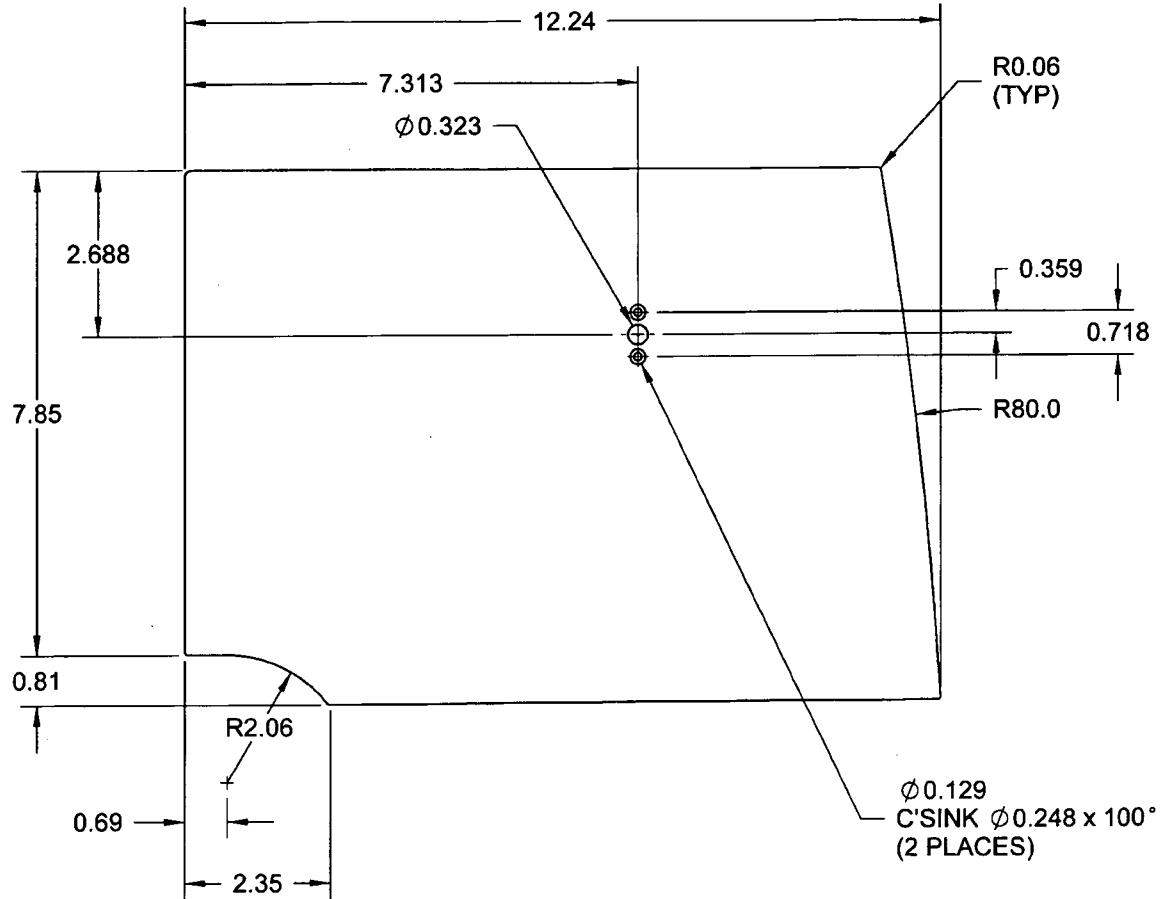
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-043/044" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i> </i>	APPROVED <i> </i>	DRAWING NO. D3594	REV. A SHEET 3 OF 3
DATE 07.04.13	TITLE DOUBLER	SCALE 1:3	

RELEASED
07.07.11
per BOM#1001

**D3594-3 FLOOR DOUBLER
(D3594-4 OPPOSITE)**

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